



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 175599



Part No: D350-591-311

Job Qty: 2 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/9/18

Job Tracking No:

Due Date: 4/13/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		4/12/18	0.00	0.00	Start Up Large Fab-4		SL
110	Large Fab	2 pcs		4/12/18	0.00	1.98	Large Fab 2		S.L
120	QC	2 pcs		4/12/18	0.00	0.00	QC9		EL
130	QC	2 pcs		4/12/18	0.00	0.00	QC5		EL
140	HandFinish	2 pcs		4/12/18	0.00	0.37	HandFinish1		SA 18-04-09
150	QC	2 pcs		4/12/18	0.00	0.00	QC7-2		CPL
180	Large Fab	2 pcs		4/12/18	0.00	1.98	Large Fab 2		SL
190	QC	2 pcs		4/12/18	0.00	0.00	QC10		38 DAS
200	QC	2 pcs		4/12/18	0.00	0.00	QC5		9-88 38
210	HandFinish	2 pcs		4/12/18	0.00	0.37	HandFinish1		SA 19-09-11
220	Powdercoat	2 pcs		4/12/18	0.00	0.58	Powdercoat1		BR 18-4-11
230	HandFinish	2 pcs		4/13/18	0.00	0.37	HandFinish3		BR 18-04-11
240	QC	2 pcs		4/13/18	0.00	0.00	QC3		6 38
250	Packaging	2 pcs		4/13/18	0.00	0.00	Packaging1-3		APR 12 2018
260	QC	2 pcs		4/13/18	0.00	0.00	QC4		Smb
265	DC	2 pcs		4/13/18	0.00	0.00	DC		
270	Packaging	2 pcs		4/13/18	0.00	0.00	Packaging3-1		DAS Smb
280	QC21-FG	2 Ea		4/13/18	0.00	0.00	QC21		21 APR 13 2018

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & DWG Descriptions: D3272 A/R Aluminum Rod M138673 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 2:50 OVEN TEMPERATURE: 320° FINISH TIME: 3:20.

265 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

2346

(2376)

Wing walk M138761

2479

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	4 Ea (2 ea)	90-Start up Operation	5049922
D3219-1	Plate	4 Ea (2 ea)	90-Start up Operation	8050520
D3272-1	Step	2 Ea (1 ea)	90-Start up Operation	5059889
D3065-041	Step Leg Assembly	2 Ea (1 ea)	180-Large Fab	5054130
D3066-1	Spacer	4 Ea (2 ea)	180-Large Fab	5051986
MS20600-AD4W4	Rivet	32 Ea (16 ea)	180-Large Fab	504171
AN3-35A	Bolt	4 Ea (2 ea)	250-Packaging	
AN4-13A	Bolt	16 Ea (8 ea)	250-Packaging	
AN5-36A	Bolt	4 Ea (2 ea)	250-Packaging	
D2230-3	Mounting Lug	8 Ea (4 ea)	250-Packaging	
D2618	Bushing	4 Ea (2 ea)	250-Packaging	
D2856-400-720	Abrasion Strip 4" X 7.20"	4 Ea (2 ea)	250-Packaging	
D3235-1	Mounting Lug	4 Ea (2 ea)	250-Packaging	
D3278-041	Support Assembly	2 Ea (1 ea)	250-Packaging	
MS21042L3	Nut	4 Ea (2 ea)	250-Packaging	
MS21042L4	Nut	16 Ea (8 ea)	250-Packaging	
MS21042L5	Nut	4 Ea (2 ea)	250-Packaging	
NAS1149D0363J	Washer	8 Ea (4 ea)	250-Packaging	
NAS1149D0463J	Washer	32 Ea (16 ea)	250-Packaging	
NAS1149D0563J	Washer	8 Ea (4 ea)	250-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	4	79	0
	D3219-1	4	93	0
	D3272-1	2	12	0
180-Large Fab	D3065-041	2	7	0
	D3066-1	4	64	0
	MS20600-AD4W4	32	1,507	0
250-Packaging	AN3-35A	4	238	0
	AN4-13A	16	900	0
	AN5-36A	4	208	0
	D2230-3	8	154	0
	D2618	4	402	0
	D2856-400-720	4	146	0
	D3235-1	4	232	0
	D3278-041	2	10	0
	MS21042L3	4	2,557	0
	MS21042L4	16	3,861	0
	MS21042L5	4	1,052	0
	NAS1149D0363J	8	2,871	0
	NAS1149D0463J	32	5,730	0
	NAS1149D0563J	8	1,794	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework Scr. Use-as Suspected Unapproved
Part No. _____	
NCR No. _____	

Date : _____	Step #: _____
--------------	---------------

Description Work Order Deviation

DART AEROSPACE

1270 Aberdeen Street
Newbury, ON K4A 1K7
CANADA
TEL: 1 813 822-8200
Email: sales@dartaero.com
www.dartaero.com

Container No: S059364

Part: D350 - 591 - 311

Job No: 175599

Serial No/Batch: S059364

Revision: _____

Inspector: _____

Date: 04/09/10

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	OTHER : _____							
Misidentified	☐	Past Due								



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
002479	S060570	AN3-35A	Bolt	S017089 /	ST348	8
002479	S060569	AN4-13A	Bolt	S045860 /	ST344	32
002479	S060568	AN5-36A	Bolt	S041116 /	ST336	8
002479	S060574	D2230-3	Mounting Lug	s051382 /	ST521	16
002479	S060571	D2618	Bushing	S043411 /	ST008	8
002479	S037326 ✓	D2856-400-720	Abrasion Strip 4" X 7.20"	S037325	ST418	3
002479	S051490 ✓	D2856-400-720	Abrasion Strip 4" X 7.20"	F160547	ST418	2
002479	S060572	D2856-400-720	Abrasion Strip 4" X 7.20"	s046950 ✓	ST418	3
002479	S049171 /	D3235-1	Mounting Lug	S049170	ST522	7
002479	S060576	D3235-1	Mounting Lug	s051314 /	ST522	1
002479	S060578	D3278-041	Support Assembly	s059873 /	ST522	4
002479	S060567	MS21042L3	Nut	S038764 /	ST303	8
002479	S060566	MS21042L4	Nut	S045901 /	ST303	32
002479	S060565	MS21042L5	Nut	S041167 /	ST303	8
002479	S060564	NAS1149D0363J	Washer	S015269 /	ST263	16
002479	S060563	NAS1149D0463J	Washer	S045845 /	ST263	64
002479	S060562	NAS1149D0563J	Washer	S039036 /	ST263	16

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 4/12/18 2:39 PM dart.quirion.sonia

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Hel-Accept-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Hel-Accept-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Hel-Accept-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Hel-Accept-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Hel-Accept-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Hel-Accept-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.